

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012407**Date Inspected:** 28-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	NA	<b>CWI Present:</b>	Yes	No			
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No	N/A
				<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG				

**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. This QA Inspector observed the following:

OBG Bays 1 through 9

This QA Inspector observed no ZPMC personnel were working on Caltrans OBG segments or tower assemblies in OBG Bays 1 through 9.

Tower Bays 10 and 11

This QA Inspector observed no ZPMC personnel were working on Caltrans OBG segments or tower assemblies in Tower Bays 10 or 11 and most of the overhead lights were turned off in both bays.

OBG Bays 13 and 14

This QA Inspector observed no ZPMC personnel were working on Caltrans OBG segments or tower assemblies in OBG Bays 13 or 14 and the majority of the overhead lights were turned off.

OBG Bay 15

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This QA Inspector observed one ZPMC worker performing air carbon arc gouging of cross beam CB6 where ZPMC appears to have tack welded temporary bracing to the edges of various bottom and side plate stiffener plates. This ZPMC worker is removing the temporary weld material from various side plate and bottom plate stiffeners. See the photographs below for additional information.

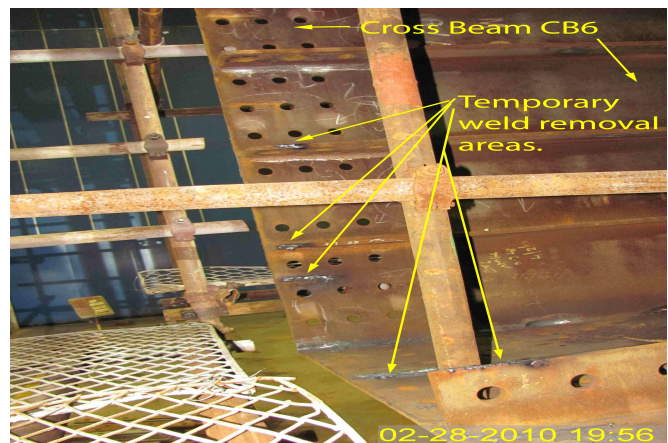
### OBG Trial Assembly

This QA Inspector observed no ZPMC personnel were welding on Caltrans OBG segments in the trial assembly area.

This QA Inspector observed six ABF personnel performing magnetic particle inspections of side plate stiffener hold back welds on OBG segments 6AW/6BW/6CW adjacent to where the OBG segments will be spliced together.

Earlier today ZPMC presented Caltrans QA with "Inspection Notification Document" #05245 which states magnetic particle and ultrasonic inspections for green tag #4 on OBG segment 6AW will be ready for Caltrans (CT QA) inspections at 1930 hours. ZPMC representative Lay Tao informed CT QA (via a phone call) that CT QA has completed UT inspections and that CT QA needs to complete MT inspections for green tag #4 welds. This QA Inspector informed Lay Tao that there were no maps available that show Green Tag #4 weld locations. CT QA asked Lay Tao if he or another ZPMC representative was on site to show Caltrans QA where Tag #4 was located and he said no ZPMC representative was on site and that this information had previously been given to CT QA and that our not having a copy of the documentation is a Caltrans internal problem. Caltrans QA Inspector Mr. Rodney Patterson later informed this QA Inspector that ZPMC has never provided CT QA with documentation that lists/shows the welds that require magnetic particle and ultrasonic inspections for green tag #4 on OBG segment 6AW. This CT QA Inspector was unable to locate any information on the green tag #4 weld locations and no inspections were performed.

Many of the ZPMC workers are not at work due to the Chinese New Year holiday, and tonight many Chinese are celebrating the Chinese Lantern Festival.



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## Summary of Conversations:

See Above.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 150-0042-2372 , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Dawson,Paul	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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